

# Work Order ID 55013

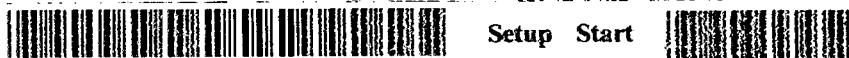


Page 1

January 5, 2010 12:46:00 PM

Item ID: D3572-041

Accept



Setup Start

Revision ID:

Item Name: Guide Assembly

8 K

Stop



Start Date: 05/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

R

Date: 10-1-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3572 Rev D

100 Pick Kit 0.00



Packaging Memo 0.00

Packaging

H 10-01-06

8 ✓

110 Small Fab 0.00

Small Fab Memo 0.00

Small Fab 1-Cut Tube D3572-1 as per Dwg D3572  
2-deburr both ends

H 10-01-06

(8) ✓ ✓

120 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

S 10-01-06

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55013**

Page 2

January 5, 2010 12:46:00 PM

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Setup Start



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Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Weld per dwg A/R Aluminum rod Batch: 111311

0.00

8

Ø

Large Fab

Memo

0.00

Large Fab

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube only

10.01.08

140



QC5- Inspect part completeness to step on W/O

0.00

⇒ S1010108

Quality Control

Memo

0.00

(8) Ø

Ø

150



QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

(8) Ø 10.01.08

W/O:		WORK ORDER CHANGES					
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January 5, 2010 12:46:00 PM

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Setup Start



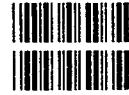
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Stop



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Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

180

Chemical Conversion Coat per QSI005 4.1



HandFinish

Memo

Hand Finishing

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

BK

10-01-11

(8)

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3



Powdercoat

M112588

0.00

MU

10-01-13

(X8)

Ø

Powder Coating

Memo

0.00

START TIME: 8:45 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:15 AM

200

QC3- Inspect Part Finish



QC

Memo

0.00

0.00

BK 10-01-13

(8)

A.

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

January 5, 2010 12:46:00 PM

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Customer:



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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

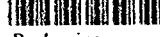
210

Identify as per dwg &amp; Stock Location

260  
0.00

10-1-13

809



Packaging

Memo

0.00

220

QC21- Final Inspection - Work Order Release

0.00

10/01/14 JH



QC

Memo

0.00

Quality Control

MF 10-1-14

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# Picklist Print

January 5, 2010 12:46:04 PM

Page 1

Work Order ID: 55013



Parent Item: D3572-041



Parent Item Name: Guide Assembly

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP Rev:F 09-04-28 As per Rev D JLM Verified By:DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Item Type	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	--------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6T1.000W.188

Purchased

No

110

f

224.1948 24.6316



*10.01.08*

6061T6 RD TUBE 1.00 X .188W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	224.1947542
109041	1.03
112529	53.5647542
<u>113511</u>	168
18101	1.6

*8*

D3572-3

Manufactured

No

130

Each

32.0000 40.0000



*10.01.08*

Guide

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST244	32
<u>52901</u>	2
<u>54118</u>	30

*32  
30*

D3572-5

Manufactured

No

130

Each

39.0000 10.0000



*10.01.08*

Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	39
<u>52657</u>	4
<u>54119</u>	35

*4  
35*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3		X		D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOP COPY

RETURN TO

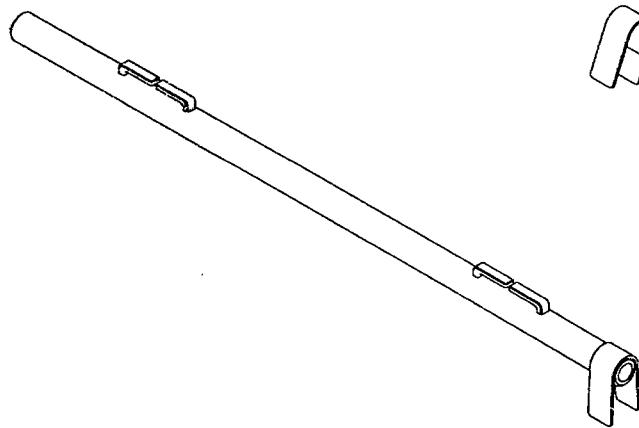
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UNCONTROLLED COPY

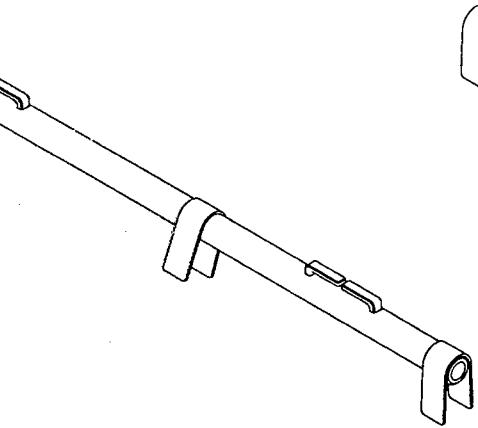
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WITHOUT NOTICE

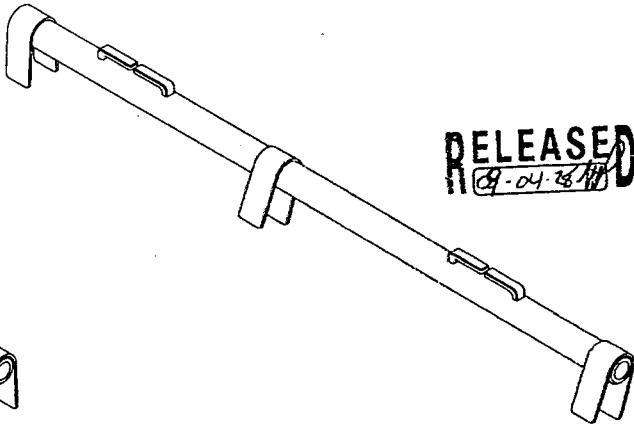
WORK ORDER

NO. 55013PL/10-1-05RELEASED  
04-04-2007

D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

## NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017			AJS	09.04.17
C	REMOVE D3572-7			LE	07.06.01
B	FOR 03573-3.0.03 CHMF WAS 0.06; ADD TYP TO FILLET			LE	07.04.20
A	NEW ISSUE			LE	07.03.29
REV.	DESCRIPTION			BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO CANADA			REV. D SHEET 1 OF 4
DRAWN	AJS				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	09.04.17	TITLE GUIDE ASSEMBLY			SCALE NTS

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W/O:		WORK ORDER CHANGES							
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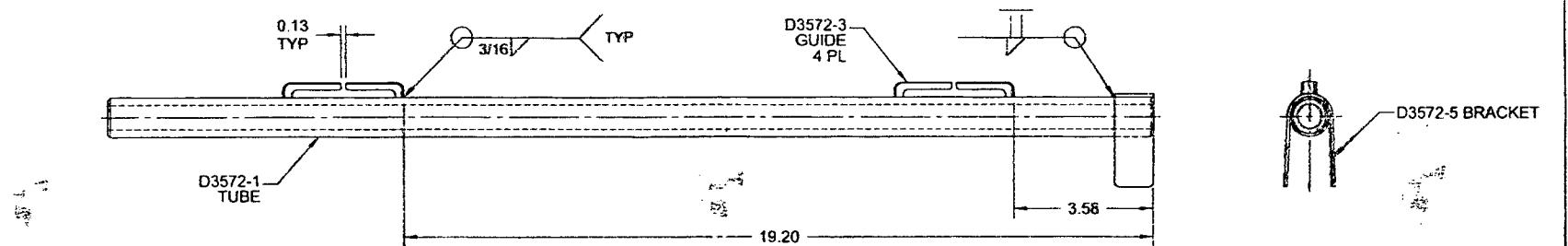
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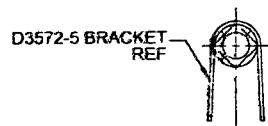
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DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

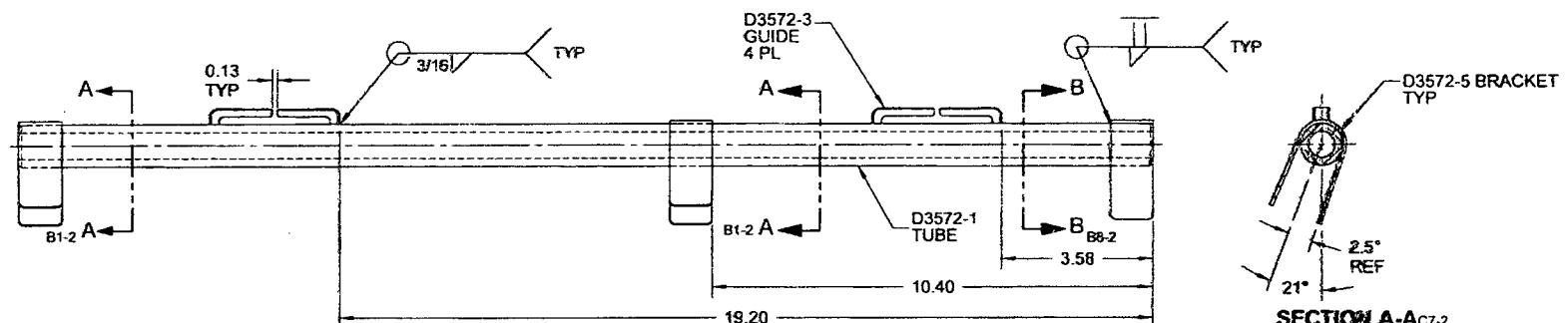
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**D3572-041 GUIDE ASSEMBLY**

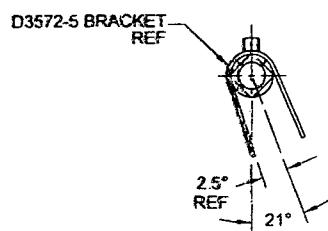


**SECTION B-B C2-2**

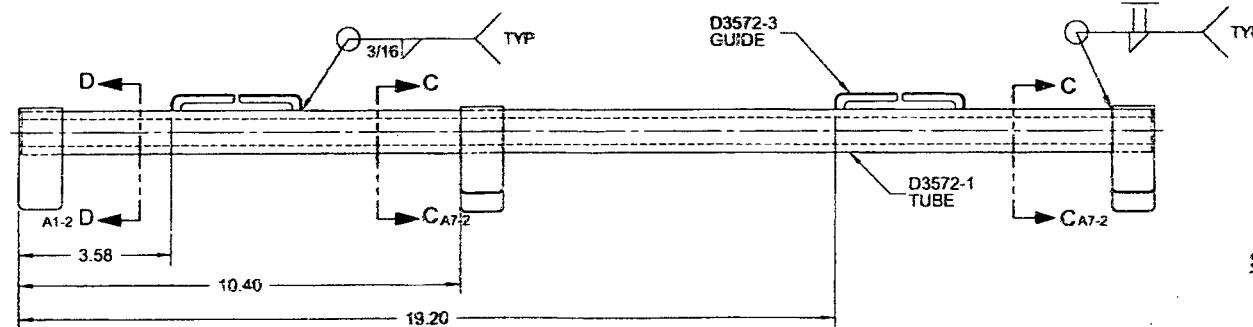


**D3572-043 GUIDE ASSEMBLY**

**RELEASED**  
09.04.17



**SECTION C-C A2-2  
A5-2**



**D3572-044 GUIDE ASSEMBLY**

**SECTION D-D A7-2**

*u6 5503*

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	E	D3572	SHEET 2 OF 4
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DE APPR.	SH	GUIDE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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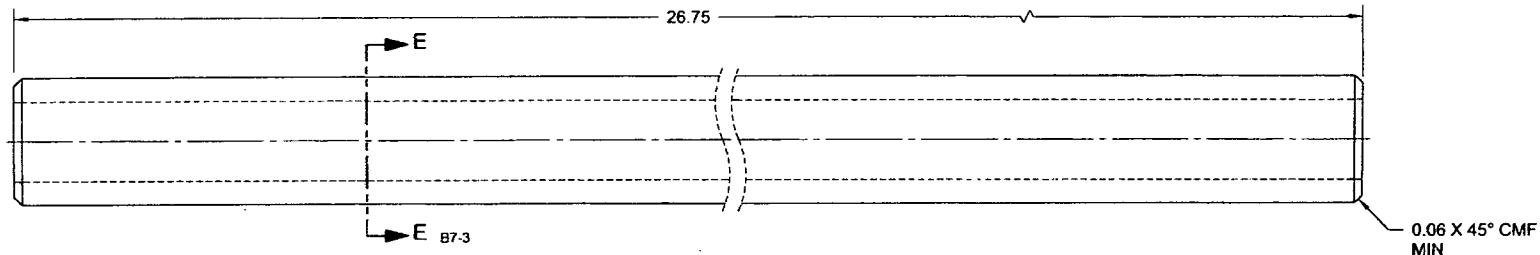
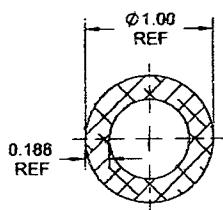
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8 7 6 5 4 3 2 1



D3572-1 TUBE

SECTION E-E CS-3

RELEASED  
09/04/13

w/o 55013

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. D
MFG. APPR.	CG	D3572	SHEET 3 OF 4
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DATE	09.04.17	NTS	

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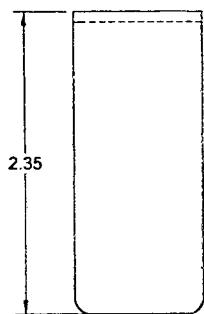
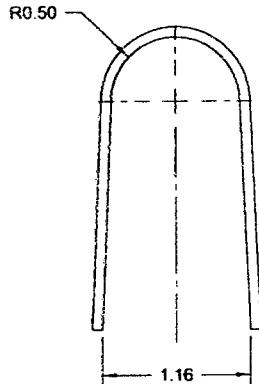
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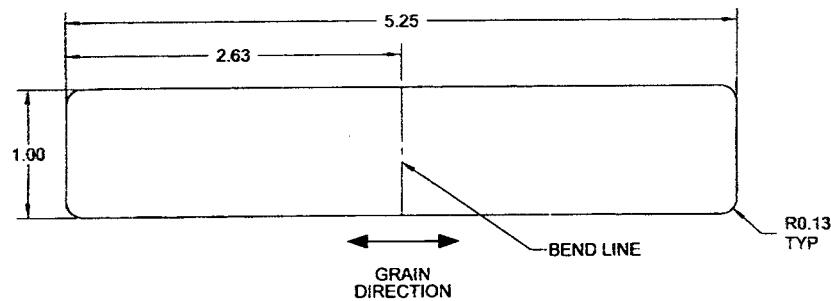
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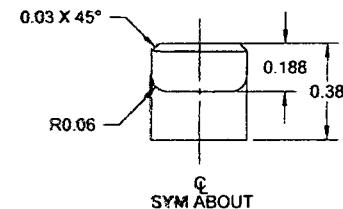
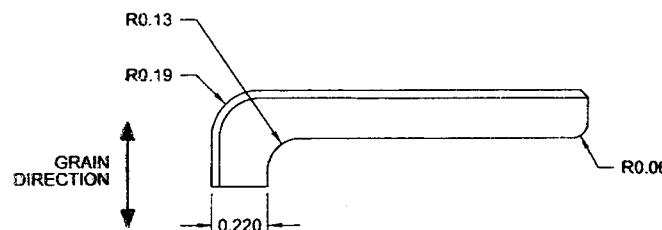
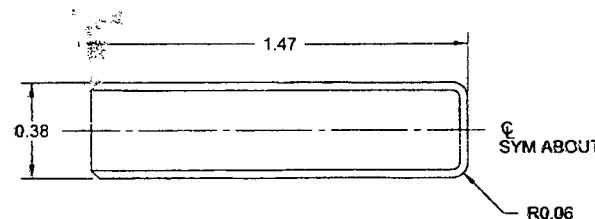
8 7 6 5 4 3 2 1



**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**

- D3572-3 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-CQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs

- D3572-5 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-CQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.04 lbs

RELEASED  
*Gaylor*

*W/0 55013*

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	B	D3572	SHEET 4 OF 4
APPROVED	C	TITLE	SCALE
DE APPR.	D	GUIDE ASSEMBLY	NTS
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